

Date: Monday, 1/7/2008 11:19:16 AM
 User: Kim Johnston

ASAP

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW ASSEMBLY
 Job Number : 36581
 Estimate Number : 10758
 P.O. Number : N/A Part Number : D3136041
 This Issue : 1/7/2008 S.O. No. : N/A Drawing Number : D3136 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : THERMOFORMING Drawing Revision : E
 Previous Run : 23709 Material : N/A
 Due Date : 1/11/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 08 01 07
 Comment : Est B 04.02.04 Reformat KJ/DS
 Est. C Thermoform in house 05/07/2007 DL
 Est D Rev E 07.09.28 EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



Comment: Qty.: 4.4625 sf(s)/Unit Total: 53.5500 sf(s)
 polycast II or plexiglass G.125"

106174 IB 8-1-8

2.0 WATER JET FLOW WATER JET



(12)

IB 8-1-8

Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-1-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/01/08 (+12)

5.0 THERMOFORMING THERMOFORMING MACHINE



(P10) 7

Comment: 1-Thermoform as per Dwg D3136 and Folio FTA006

Dwg Rev. Folio Rev. 08/01/08 (x10)
08/01/09 (x2)

BR

2- Engrave Part # and Batch # , and affix labels
 (D3136-1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: TD Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/09	#5.0	one window SCRAP at the thermobarrier after forming window was placed at the bottom of	<i>[Signature]</i> 08/01/12	SCRAP and destroy NO REPLACE No replace Identify the part with the material batch #, and re- form, and add to next w/o.	<i>[Signature]</i> 08/01/09	<i>[Signature]</i> 08/01/11	<i>[Signature]</i> 08/01/12	<i>[Signature]</i> 08/01/09
		Stack on water west Flat.						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 36581

Part Number: D3136041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformance.

BB (11) 08/01/09

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB (11) 08/01/10 (14)

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

BB (11) 08/01/09

9.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part# Description Batch
2 D3108-9 Decal B-3454

BB (11) 08/01/09

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB (11) 08/01/10 (14)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 215

8/1/10 SD (11X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11) 08/01/10

Job Completion



mi 2008/1/4
W

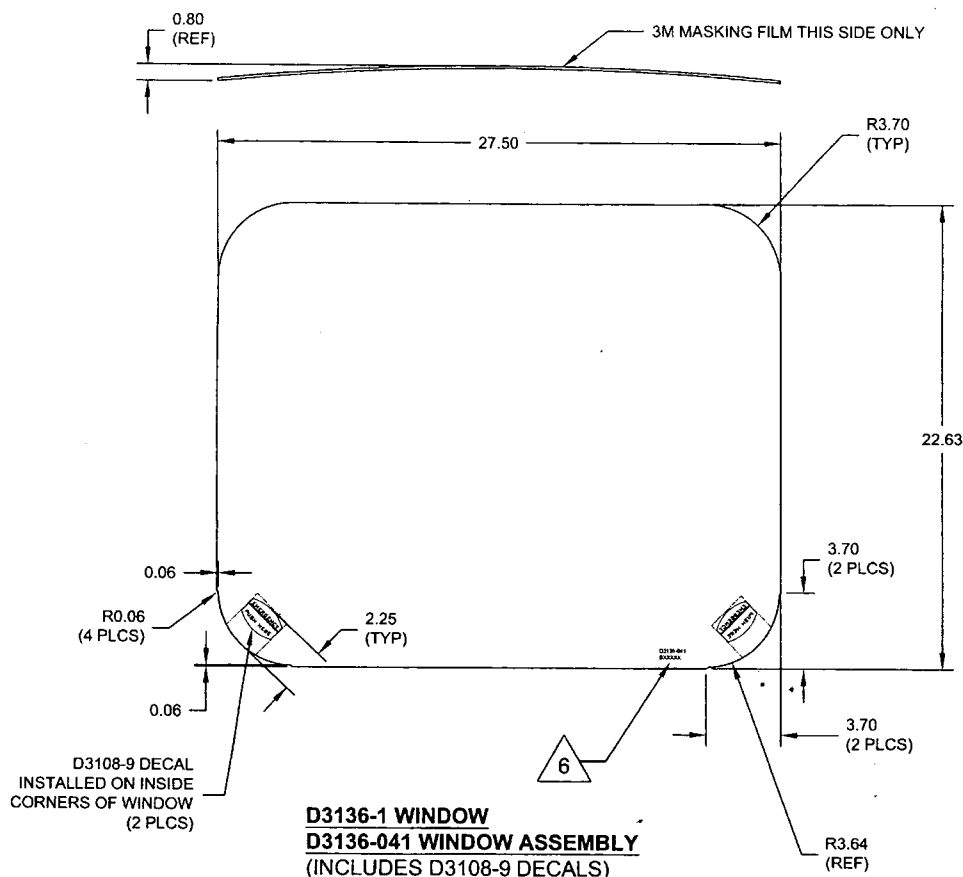
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MOLD PER
DART TOOL
DT3136-T1

0.125
(REF)

R140
(REF)

0.58
(REF)

RELEASED
07.09.10

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

NO. 36581
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

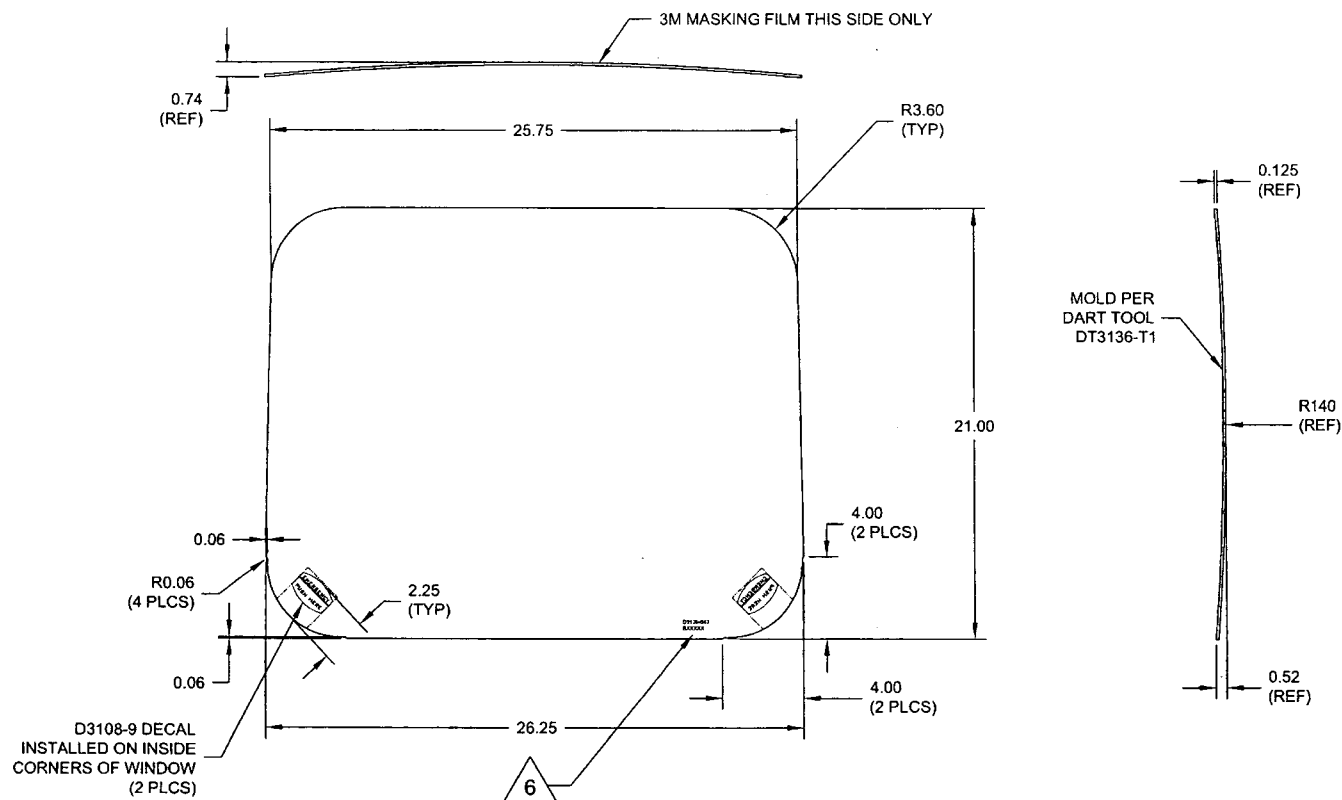
E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3136
TITLE WINDOW ASSEMBLY
SCALE 1:6

REV. E
SHEET 1 OF 2

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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D3136	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	WINDOW ASSEMBLY	1:1
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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NO. 36581
 WORK ORDER
 WITHOUT NOTICE
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 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
 07.09.22

